

# Work Order ID 71808 / 806

Tuesday, July 12, 2011 12:05:49 PM



Page 1

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 11-07-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4032

D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/7/12

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

\*\*\*\*Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*\*

11/07/2012

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






**NOTE:** Date & initial all entries



**Work Order ID 71808**



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Page 2

Item ID: D4032-041      Accept            Setup      Start        
Revision ID:      Stop        
Item Name: Short Basket Assembly (350)  
Start Date: 7/12/2011      Start Qty: 1.00            Cust Item ID:  
Required Date: 7/22/2011      Req'd Qty: 1.00            Customer:  
Reference:

Approvals:      Process Plan:      Date:      Tooling:      Date:      Run      Start        
QC:      Date:      SPC (Y/N):      Date:      Stop      

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo <i>P/N 71806</i>	0.00  0.00							<i>6/17/2011</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>11/7/20</i> <i>mf</i> <i>11-07-20</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)




Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC  
per PA3 DD 10.03.10 verified by:EC  
10.03.23 verified by:EC  
verified by:EC  
IPP Rev:B as  
IPP Rev:C as per RevA DD  
IPP Rev:D as per dwg revC DD 10.04.20  
IPP Rev:E as per dwg revD DD 10.08.18 verified  
by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232  Placard, Max Load		Manufactured	No			100	Each	5.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST122			5						
				66274			5						
D2530  Handle Weldment		Manufactured	No			100	Each	6.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST508			6						
				69318			6						
D2535  Spring		Manufactured	No			100	Each	117.0000	2				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST504			117						
				69495			17						
				71117			100						

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each

22.0000 2



Bushing



2

Location

Loc Qty

Loc Code

ST504

22

69894

22

D3917-3

Manufactured No

100 Each

51.0000 6



Washer



2

Location

Loc Qty

Loc Code

ST092

51

69513

11

69896

40

D3953-3

Manufactured No

100 Each

16.0000 2



Gas Spring Stud, Lid



2

Location

Loc Qty

Loc Code

ST096

16

69974

16

D3953-7

Manufactured No

100 Each

15.0000 2



Spring Spacer



2

Location

Loc Qty

Loc Code

ST096

15

65053

4

69975

11

2

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-9 Manufactured No

100 Each

17.0000

2



Gas Spring Washer

Location

Loc Qty

Loc Code

ST096

17

69025

5

69973

12

D3953-17 Manufactured No

100 Each

11.0000

2



Gas Spring Spacer

Location

Loc Qty

Loc Code

ST096

11

69603

11

D3953-19 Manufactured No

100 Each

15.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST096

15

59213

1

68462

14

D3953-21 Manufactured No

100 Each

14.0000

1



Gas Spring Bracket

Location

Loc Qty

Loc Code

ST096

14

68463

14

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3969-3  
Spring (Basket Lid)

Manufactured No

100 Each

15.0000

1

1

Location

Loc Qty

Loc Code

ST272

15

64285

1

68925

14

D4017-041  
Short Basket Base Assembly (350 )

Manufactured No

100 Each

0.0000

1

1

D4018-041  
Short Basket Lid Assembly (350 )

Manufactured No

100 Each

0.0000

1

1

AN3-14A  
Bolt

Purchased No

100 Each

120.0000

4

4

Location

Loc Qty

Loc Code

ST352

120

117688

20

117872

100

AN3-16A  
Bolt

Purchased No

100 Each

101.0000

2

2

Location

Loc Qty

Loc Code

ST352

101

116419

1

117441

100

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

AN4-12 Purchased No 100 Each 57.0000 3  
Bolt

Location Loc Qty Loc Code

ST357 57  
117514 57

AN5-17A Purchased No 100 Each 80.0000 4  
Bolt

Location Loc Qty Loc Code

ST339 80  
117619 36  
117872 44

AN310-4 Purchased No 100 Each 82.0000 3  
NUT

Location Loc Qty Loc Code

ST324 82  
118078 32  
118112 50

AN310C4 Purchased No 100 Each 53.0000 2  
Nut

Location Loc Qty Loc Code

ST324 53  
116741 1  
117395 42  
118090 10

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

100

Each

1,749.000

6



Nut

Location

Loc Qty

Loc Code

ST300

1749

116549

89

117441

800

117601

400

117885

460

MS21042L5

Purchased

No

100

Each

1,392.000

4



Nut

Location

Loc Qty

Loc Code

ST300

1392

116105

5

116548

203

117441

498

117591

100

117611

90

118179

496

MS24665-151

Purchased

No

100

Each

459.0000

3



Cotter Pin

Location

Loc Qty

Loc Code

ST309

459

17566

459

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 71808

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-300

Purchased

No

100

Each

270.0000

2



Cotter Pin

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

70

116823

70

NAS1149F0432P

Purchased

No

100

Each

348.0000

6



Washer

Location

Loc Qty

Loc Code

ST275

348

117291

148

118179

200

NAS1149C0432R

Purchased

No

100

Each

4,996.000

2



Washer

Location

Loc Qty

Loc Code

ST297

4996

116900

378

117291

4618

NAS1149F0332P

Purchased

No

100

Each

170.0000

8



WASHER

Location

Loc Qty

Loc Code

ST275

170

117735

160

17317

10

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, July 12, 2011 12:05:46 PM

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Work Order ID: 71808



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 7/12/2011

Required Date: 7/22/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

224.0000

4

4



Washer



5/11/7/PS

Location

Loc Qty

Loc Code

ST275

24

114576

24

ST297

200

117735

200

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

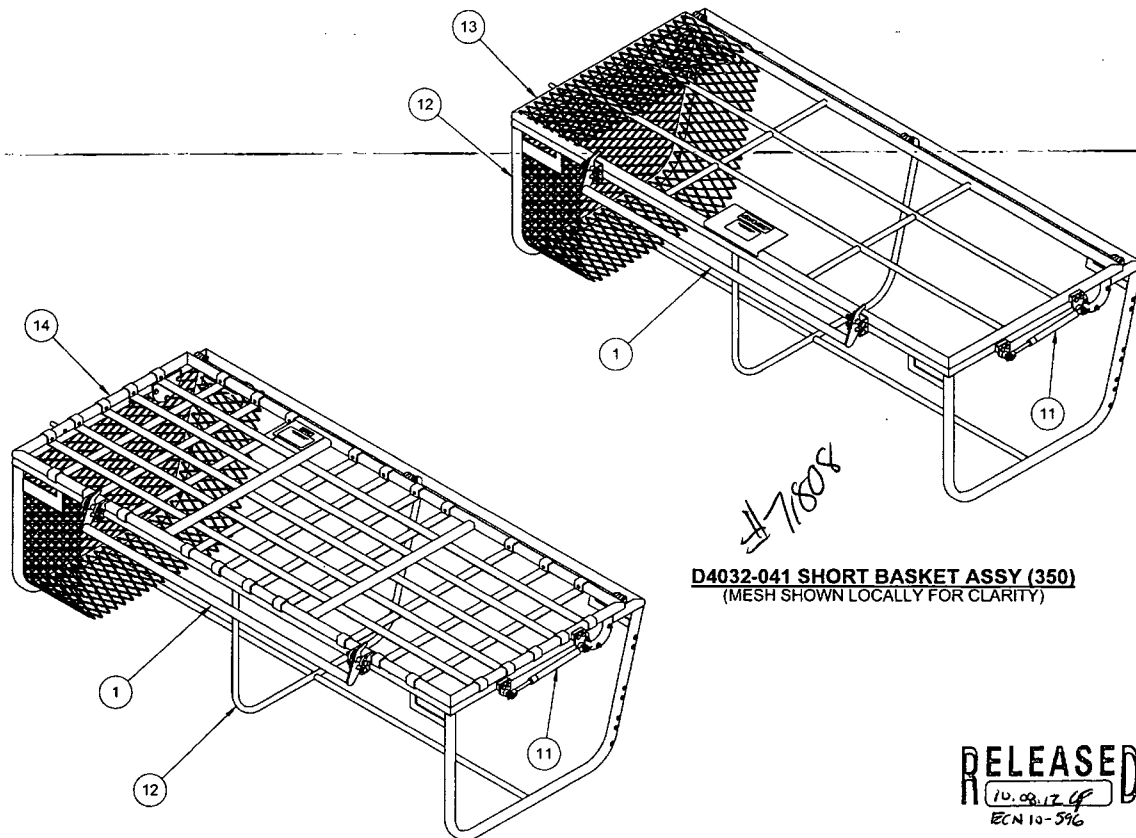
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



**D4032-041 SHORT BASKET ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

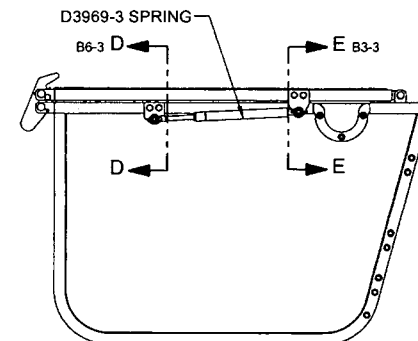
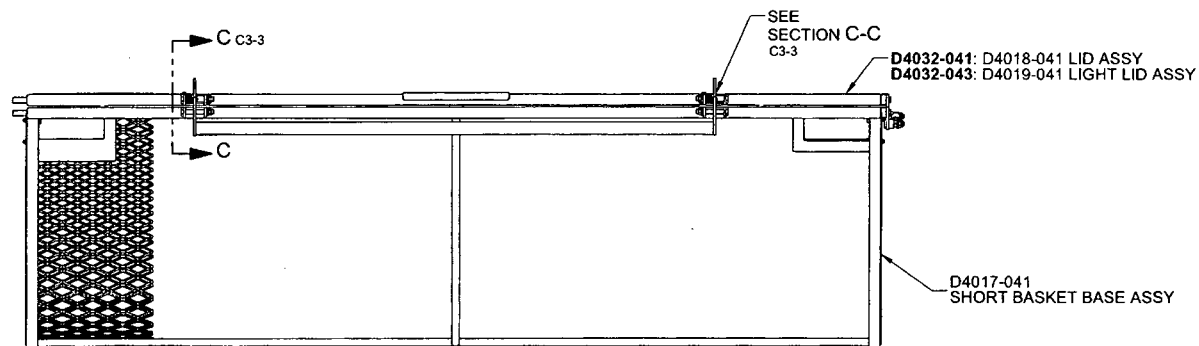
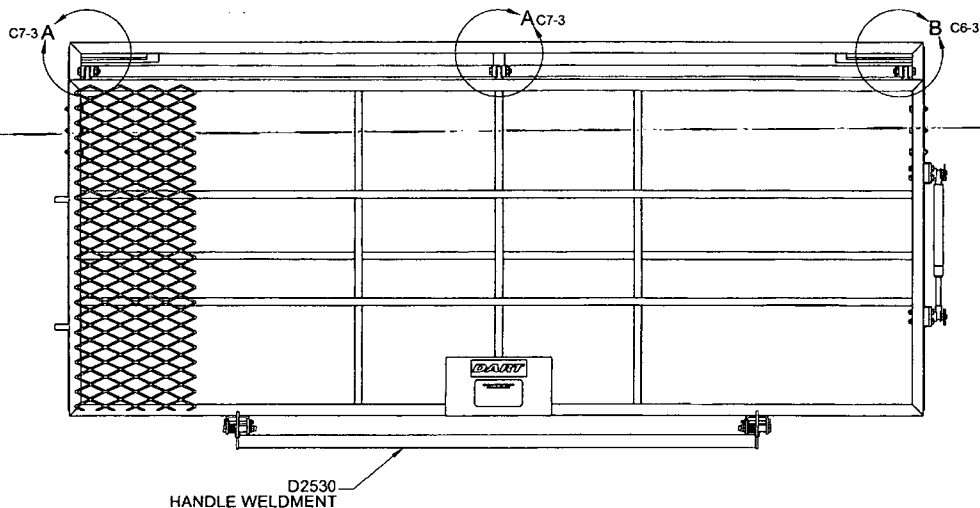
**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.09.12  
ECN 10-596

NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: N/A  
6) IDENTIFICATION: N/A  
7) WEIGHT: -041: 56 lbs APPROX  
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3).	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED, ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AGS		
DRAWN	JP		
CHECKED			
MFG. APPR.	JPS		
APPROVED	JP		
DE APPR.			
DATE	10.07.23		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4032</b> SHEET 1 OF 3 TITLE <b>SHORT BASKET ASSY (350)</b> SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1



**D4032-041 SHORT BASKET ASSY (350) (SHOWN)**  
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)  
**D4032-043 SHORT BASKET ASSY, LIGHT LID (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

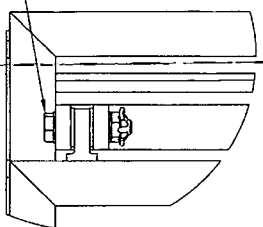
RELEASED  
10.08.2023

DESIGN	AIS	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4032</b>	REV. D
MFG. APPR.	JFS	SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		<b>SHORT BASKET ASSY (350)</b>	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

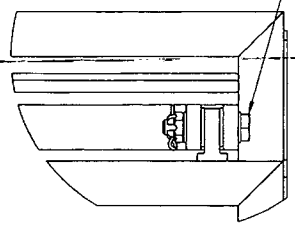
8 7 6 5 4 3 2 1

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



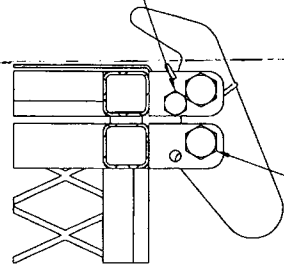
**DETAIL A** D8-2  
D6-2

AN4-12 BOLT  
D3917-3 WASHER, 2X  
NAS1149F0432P WASHER, 2X  
AN310-4 NUT, CASTELLATED  
MS24665-151 COTTER PIN



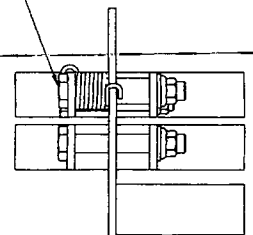
**DETAIL B** D4-2

D4032-041: AN3-16A BOLT  
MS21042L3 NUT  
D4032-043: AN3-20A BOLT  
MS21042L3 NUT



**SECTION C-C** B5-2  
B7-2

D4032-041: AN5-17A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT  
D4032-043: AN5-21A BOLT  
D2537 BUSHING  
D2535 SPRING  
NAS1149F0563P WASHER  
MS21042L5 NUT



**VIEW F-F** C3-3

AN5-17A BOLT  
NAS1149F0563P WASHER  
MS21042L5 NUT

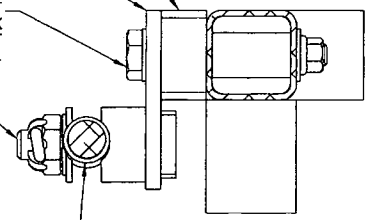
*7/658*

D2530 WELDMENT  
REF

D3953-17 GAS SPRING SPACER  
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL

D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN



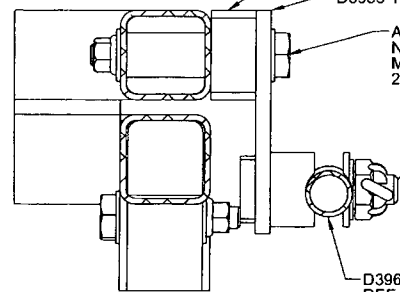
D3969-3 SPRING  
REF

**SECTION D-D** B2-2

D3953-17 GAS SPRING SPACER

D3953-19 GAS SPRING BRACKET

AN3-14A BOLT  
NAS1149F0332P WASHER, 2X  
MS21042L3 NUT  
2 PL



D3953-3 GAS SPRING STUD, LID  
D3953-7 GAS SPRING SPACER  
D3953-9 GAS SPRING SPACER  
NAS1149C0432R WASHER  
AN310C4 NUT, CASTELLATED  
MS24665-300 COTTER PIN

D3969-3 SPRING  
REF

**SECTION E-E** B1-2

**RELEASED**  
10.07.23

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